



- NOTE AND ASSEMBLY SEQUENCE OF UPPER COOLING UNIT:
1. BRAZED MESH; ITEM 3, ONTO THE COOLING INNER TUBE; ITEM 2, AS SHOWN.
 2. INSERT FINISHED COOLING INNER TUBE IN Ø500 HOLE OF FINISHED COOLING TUBE AND PUSH FINISHED COOLING INNER TUBE TO END OF HOLE.
 3. BEND BOTH COOLING INNER AND COOLING TUBES TOGETHER AS SHOWN.
 4. CUT BOTH COOLING INNER AND COOLING TUBES TO SIZE (IF NECESSARY).
 5. SLIDE COOLING EXPLOSIVE BONDING TUBE; ITEM 4, & MODIFIED ROT. FLANGE (INNER PART); ITEM 8, RESPECTIVELY ONTO COOLING TUBE; ITEM 1.
 6. BRAZE COOLING EXPLOSIVE BONDING TUBE; ITEM 4, TO COOLING TUBE; ITEM 1, AS SHOWN.
 7. TIG WELD COOLING MODIFIED ROT. FLANGE (INNER PART); ITEM 8 TO COOLING EXPLOSIVE BONDING TUBE; ITEM 4.
 8. SILVER SOLDER COOLING EXIT PORT; ITEM 5, ONTO THE COOLING TUBE; ITEM 1, AS SHOWN.
 9. SILVER SOLDER COOLING PORT SUPPORT, ITEM 7, ONTO COOLING EXIT PORT; ITEM 5, AS SHOWN.
 10. SILVER SOLDER COOLING ENTRANCE PORT; ITEM 6, ONTO COOLING INNER TUBE; ITEM 2, AND SILVER SOLDER PORT SUPPORT; ITEM 7, AS SHOWN.
 11. PRIOR TO INSTALL SWAGelok MALE CONNECTORS, USE CAJON PIPE THREAD SEALANT MS-TFS-50 TO ALLOW CONNECTION TO BE DISASSEMBLED WITHOUT SPECIAL TOOLS.
 12. WATER PRESSURE TEST AT 500 P.S.I. AFTER WELDING AND ASSEMBLING.
 13. ALL DIMENSIONS IN [] ARE MILLIMETERS AND FOR REFERENCE ONLY.

9	SS-600-1-4	SWAGelok MALE CONNECTOR 250-18 N.P.T.	SST 316	2
A15569	8	P4105091505-210108-00L5 UPPER COOLING MODIFIED ROT. FLANGE	SST 304	1
A15568	7	P4105091505-210107-00L5 UPPER COOLING PORT SUPPORT	O.F.H.C. COPPER	1
A15567	6	P4105091505-210106-00L5 UPPER COOLING ENTRANCE PORT	O.F.H.C. COPPER	1
A15566	5	P4105091505-210105-00L5 UPPER COOLING EXIT PORT	O.F.H.C. COPPER	1
A15565	4	P4105091505-210104-00L5 UPPER COOLING EXPLOSIVE BONDING TUBE	O.F.H.C. / SST 304	1
A15564	3	P4105091505-210103-00L5 UPPER COOLING MESH	COPPER	1
A15582	2	P4105091505-220102-00L5 LOWER COOLING INNER TUBE	O.F.H.C. COPPER	1
A15581	1	P4105091505-220101-00L5 LOWER COOLING TUBE	O.F.H.C. COPPER	1

LOG	ITEM	DESCRIPTION	REVISIONS	DATE	BY	CHKD	APP'D

PARTS LIST			
ITEM	DESCRIPTION	QTY	REMARKS
1	SS-600-1-4	2	
2	P4105091505-220102-00L5	1	
3	P4105091505-210103-00L5	1	
4	P4105091505-210104-00L5	1	
5	P4105091505-210105-00L5	1	
6	P4105091505-210106-00L5	1	
7	P4105091505-210107-00L5	1	
8	P4105091505-210108-00L5	1	

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